

Date: Wednesday, 1/4/2006 2:37:10 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SPACER
<b>Job Number</b> : 25395A	
<b>Estimate Number</b> : 10352	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D2280
<b>This Issue</b> : 1/4/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2280 REV D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : D
<b>Previous Run</b> : 25089A	<b>Material</b> : N/A
<b>Written By</b> : <u>See comment below</u>	<b>Due Date</b> : 1/25/2006 <b>Qty:</b> 40 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>See above user</u>	
<b>Comment</b> : Est Rev:A New Issue 05-11-07 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6B0250X01000	6061-T6 Bar .25" x 1.0"
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**Comment:** Qty.: 0.2975 f(s)/Unit Total: 11.8986 f(s)  
 Material: 6061-T6 (QQ-A-250/8) 0.25" Thick  
 (M6061T6B0.250x1.000) Identify as D2280  
 Batch: M12258

J.L 06-02-04

2.0	SHEAR	SHEAR
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**Comment:** SHEAR  
 Cut blank: (3.400") +/-0.020"

J.L 06-02-04

40

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

1-Machine per folio D2280 and Dwg D2280

2-Deburr Then Tumble N/A

J.L 06-02-04

40

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.L 06-02-04

40

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

Ep 06/02/05

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/02/04

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/4/2006 2:37:11 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 25395A

Part Number: D2280

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAN 06/02/08 40

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/02/08 40

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SP 06/02/23 40

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/02/23 40

Job Completion



U 06/02/23

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	25395 A
<b>Description:</b> Spacer		<b>Part Number:</b>	D2280
<b>Inspection Dwg:</b> D2280 <b>Rev:</b> C1			<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

<input checked="" type="checkbox"/>	First Article	<input type="checkbox"/>	Prototype
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[illegible]

Measured by:	JL	Audited by:	MS	Prototype Approval:	N/A
Date:	06-02-04	Date:	06/02/04	Date:	N/A

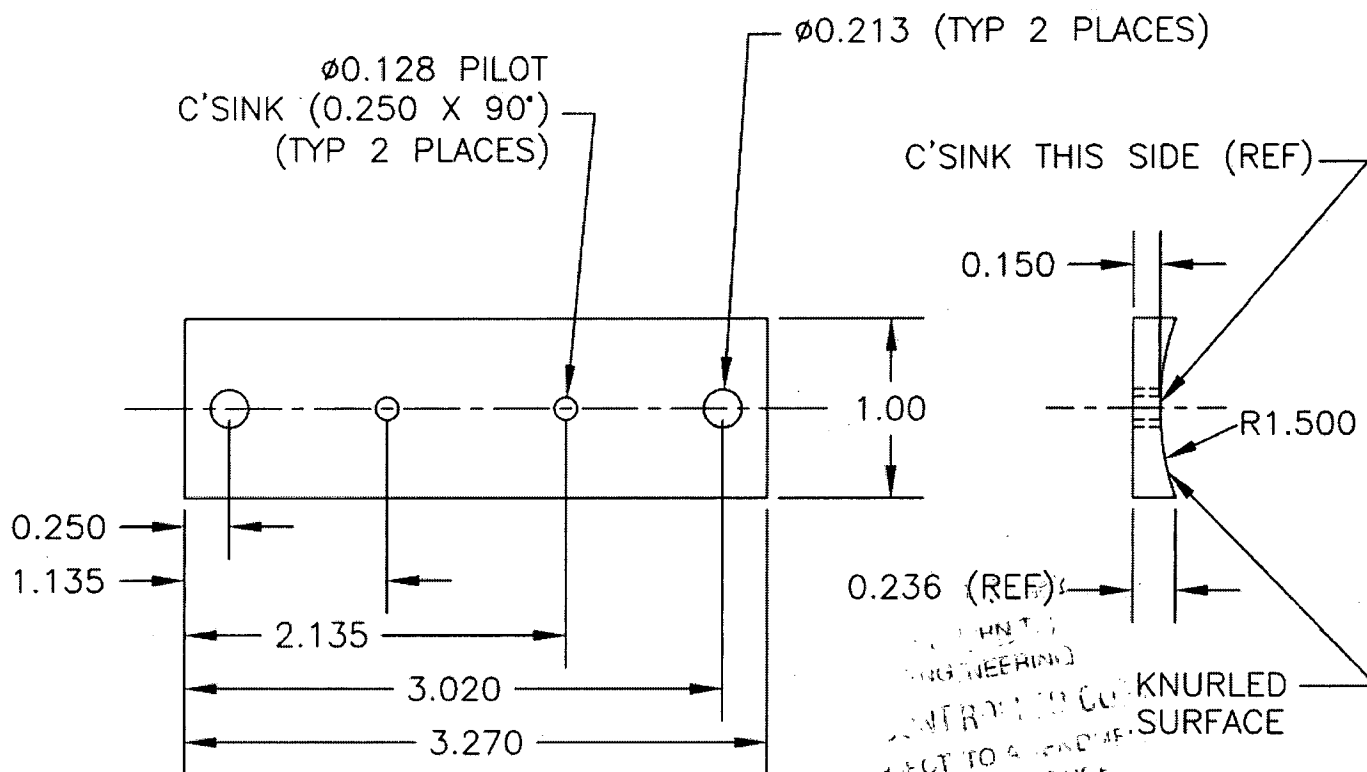
Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue P/O D2582	KJ/JLM	





DESIGN <i>[Signature]</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2280	REV. D SHEET 1 OF 1
DATE 05.11.14		TITLE SPACER	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.22	MATERIAL CHANGE, 0.15 WAS 0.20	
C	98.09.29	0.188 DIA HOLE CHANGED TO 0.213	
D	05.11.14	ADD FINISHING NOTE	

RELEASED  
05.11.28 *[Signature]*



#### D2280 SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8) BAR, 0.250 X 1.000  
(REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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